Work Orde Wednesday, Ma												Page 1
Item ID: Revision ID:	D3898-1			Accept					Setup	Start		
Item Name:	Floor Protecto	or (206L)		30+51)						Stop		
Start Date: Required Date: Reference:	5/19/2010 5/26/2010	Start Qty: 2.00 Req'd Qty: 2.00	i III/II 146 i 1100)a 146 i		Cust Item I Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling:	Da	nte:	_		Run	Start		
••			Date:	SPC (Y/N):		ite:				Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr								•		
D3898	Rev	Α -										
Hand Finishing The	rmoforming	Memo 1-Cut She	et to required Blank size	0.00						H	10/	105/26.
105		Dry material		0.00								
HandThermo		Memo		0.00								
Hand Finishing The	rmoforming	Dry Sheet Temp: Time IN:_ Time OU	~(10/05/25							3	B (0/05/2

33 10/05/25 02 10/05/26

W/O:			W	ORK ORDER CHANGI	ES		****	1
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-	Prod Mgr	
Part No:		PAR #:			NCR: Yes I	No DOA:	Date:	
Resolution:								
NCR:		T		ER NON-CONFORMA				
DATE	STEP	Description of NC		Corrective Action Section	Verification	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 58848

Wednesday, May 19, 2010 1:40:32 PM



Page 2

Item ID:

D3898-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Floor Protector (206L)

Start Date:

5/19/2010

Start Qty: 2.00

Req'd Qty: 2.00 **Required Date:** 5/26/2010



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/

Work Center ID

Operation Description

Set Up/ **Run Hours**

0.00

0.00

Draw Number Rev.

Draw Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

110

Thermoform

Thermoforming Machine

Memo

QC: _____ Date:

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501

Dwg Rev: Folio Rev:

120

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Memo

Quality Control

Visually inspect part for proper formation and texture

130

Memo

QC8- Inspect parts - second check

Quality Control

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _					
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NCR: ,		1	WORK ORD	ER NON-CONFORMA	ANCE (NCR)						
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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Wednesday, May 19, 2010 1:40:32 PM



Page 3

Item ID:

D3898-1

Accept

Setup Start



Revision ID:

Item Name:

Floor Protector (206L)

Start Date:

Required Date: 5/26/2010

5/19/2010

Start Qty: 2.00

Req'd Qty: 2.00



Date:_____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Stop



Sequence ID/

Work Center ID

Operation Description

Set Up/ **Run Hours** Draw Number

Draw Plan Rev. Code Accept Qty

Reject Qty

Reject Insp. Number

140

HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

0.00

0.00

Stamp

150

QC

Memo

Quality Control

Complete FAI document

QC5- Inspect part completeness to step on W/O

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

160

Memo

Quality Control

W/O:	-			ORK ORDER CHANG	EC				5	
DATE	STEP	PRO	OCEDURE CH	· · · · · · · · · · · · · · · · · · ·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Work Order ID 58848

Wednesday, May 19, 2010 1:40:32 PM



Page 4

Item ID:

D3898-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Floor Protector (206L)

Start Date:

5/19/2010

Start Qty: 2.00

Required Date: 5/26/2010

Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Δn	provals:
ΑÞ	pi uvais.

Process Plan: _____ Date: ____

Tooling:

Date:

Run

Start

Stop



QC: _____ Date:___

Operation

Description

SPC (Y/N):

Set Up/

Run Hours

Draw

Number

Date:

Plan

Code

Draw

Rev.

Accept

Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

170

Packaging

Memo

Memo

0.00 0.00

10-5-31

Packaging

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

0.00

10/06/01 H)

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W/O:			W	ORK ORDER CHANG	GES				. 34
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

Wednesday, May 19, 2010 1:40:36 PM

Work Order ID: 58848

Parent Item:

D3898-1

Parent Item Name:

Floor Protector (206L)

Comments:

IPP Rev.A New Issue 09/02/06 DL

Add Step 105 Dry Material 10/04/21 DL

IPP RevB

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name

Item ID

Replacement Mfg/ Purch Purchased

Bin **Primary** Item Location No

Last Location Route Seq ID 100

Unit of Qty on Measure Hand sf 2,670.830

Qty per Kit

10.6

Qty Issued

Date **Issued**

Status

MLEXS.118-90318-08

Lexan Sheet

Location

therm

Loc Qty

2670.83 2670.83 Loc Code

21.2 sg ft. DL 10/05/25

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W/O:			WO	RK ORDER CHANGE	S				· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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DART AEROSP	ACE LTD			Wo	ork Order:	58848
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Description: Floor	Protector	· · · · · · · · · · · · · · · · · · ·		Pa	rt Number:	D3898-1
Inspection Dwg: D	3898 Rev : A					Page 1 of 1
	FIRST A	RTICLE INSF	PECTION	CHECK	LICT	
	X	First Article	L	Prototy	oe	
	Ti	HERMOFORM	MING SE	CTION		
Description			Accept	Reject	Method of Inspection	Comments
Inside Radii less tha	an"		~			
Shape Definition						
Texture Retention						
Material imperfectio scratching	ns such as bumps,	cracks, voids,				
Scratching						
						1 700 100
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Measured by:	Ol				Data	1 -/
weasured by.	Dh-				Date:	14/05/26
		TRIMMING	SECTIO	N		
Drawing		TRIMMING Actual			Method of	
Drawing Dimension	Tolerance		Accept	N Reject	Method of Inspection	Comments
_	Tolerance Min	Actual Dimension				Comments
Dimension		Actual Dimension @ .50 "	Accept			Comments
0.50 1.00 5.6	Min	Actual Dimension @ .50 "	Accept			Comments
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0.50 1.00 5.6 0.080 0.050 Measured b	Min +0.2/-0.0 Min Min Min y: y: 38	Actual Dimension @.50" 1.00" 5.4" @.083" @.065"	Accept		Inspection Date:	10/05/26
Dimension 0.50 1.00 5.6 0.080 0.050 Measured by Audited by Prototype Approva	Min +0.2/-0.0 Min Min Min y: y: 38	Actual Dimension @.50" 1.00" 5.4" @.083" @.065"	Accept		Date:	10/05/26 10/05/27 N/A

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W/O:			W	ORK ORDER CHANG	ES				1
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SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 5-9848 PO 10-3-19

D3898-1 FLOOR PROTECTOR (206L)

NOTES:
1) MATÉRIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS

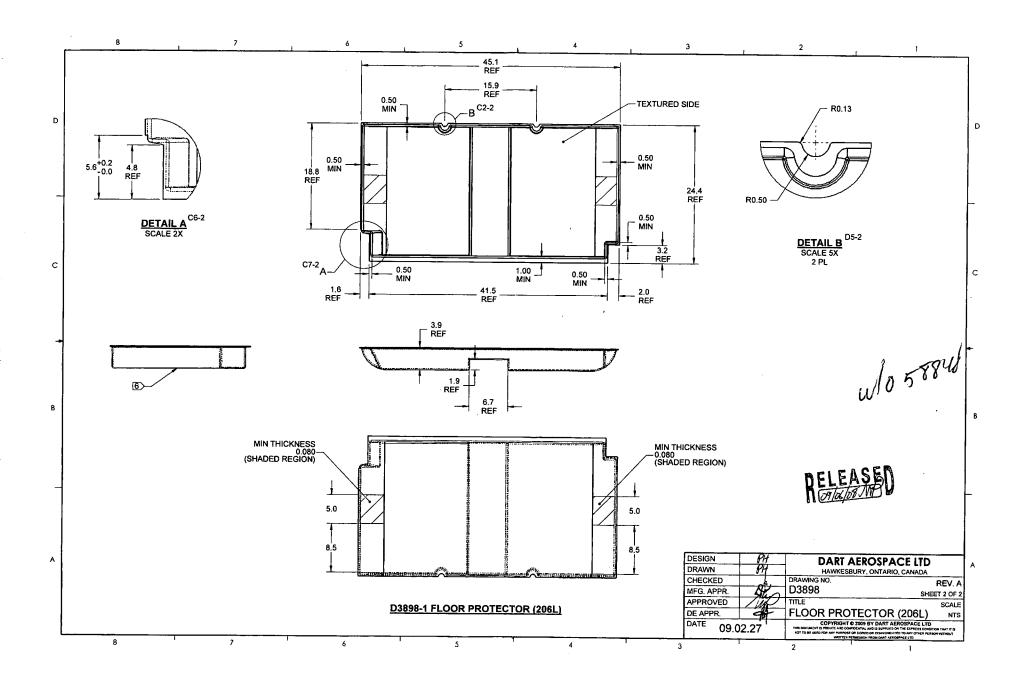
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С

7) WEIGHT: 5.0 lbs 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A NEW ISSUE 09.02.27 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3898 MFG. APPR. SHEET 1 OF 2 TITLE APPROVED SCALE FLOOR PROTECTOR (206L) DE APPR. DATE COPYRIGHT © 2009 BY DART AEROSPACE LTD 09.02.27

W/O:			ORK ORDER CHANG	HANGES						
DATE	STEP	PRO	OCEDURE CH		Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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W/O:		WORK ORDER CHANGES							
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